

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009469**Date Inspected:** 28-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming, Lvli Qian**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/ OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY# 14

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-10AW

SMAW welding process of weld joint 38 located on PCMK SP776-001. Welder is identified as 050316 ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2.

OBG SEGMENT-9DE

SMAW welding process of weld joint 129 located on PCMK CSD2-PP81.5. Welder is identified as 216086 ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the WPS-B-P-4113.

SMAW welding process of weld joint 045 located on PCMK SEG056*. Welder is identified as 049779 ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

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BAY#10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 2A located on PCMK NSD1-SDSA3-56. Welder is identified as 040533 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U2-F.

FCAW welding process of weld joint 034 located on SSTL4-1G/L. Welder is identified as 052075 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132.

FCAW welding process of weld joint 53 located on PCMK SSTL4-1C/L. Welder is identified as 054069 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 5BW-5CW

This QA Inspector observed ABF NDT inspector performing magnetic particle inspection on the upper floor beam flange weld at PP34, 35, 36

INCIDENT

BAY #10

NORTH TOWER LIFT # 3

This Quality Assurance Inspector observed ZPMC personnel performed free hand thermal cutting on diagonal stiffener. The diagonal stiffener will be located between 85m diaphragm and 89m diaphragm at the skin B and C corner. The length of free hand cut was approximately 850mm. For additional information see attached photos.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer